

Date: Monday, 5/15/2006 11:12:11 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER
Job Number	: 27116		
Estimate Number	: 11063		
P.O. Number	: N/A	Part Number	: D2935
This Issue	: 5/15/2006 S.O. No. : N/A	Drawing Number	: D2935 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 5/15/2006 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25379	Material	: N/A
Written By	: <u>LAKE COMMENT BELOW</u>	Due Date	: 5/30/2006
Checked & Approved By	: <u>06.05.15</u>	Qty:	40 Um: Each
Comment	: Est A 00.06.06 New Issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s)

6061-76 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" Thick

Batch M19295

per attached dwg.

M 06 05 31

2.0	SHEAR	SHEAR
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Comment: SHEAR

1 blank makes 4 parts

Blank: 7.90" x 3.70" (+0.030" -0.000")

N/A

06.05.25

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA073

Tumble JAD 06.06.01

Deburr any rough edges after tumbling

water jet.

M 06 05 31 (40)

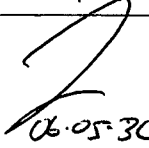
H.M 06/05/31

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M 06 05 31 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-30	1.0	New GOGI-T6 .080. See attached. mat'l being revised by Engineering					 06-05-30	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/05

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 5/15/2006 11:12:11 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27116

Part Number: D2935

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 06/06/02 (40)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC 06 06 02 (40)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 6/6/5 (40)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 395

PU 6/6/05 (40)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/06/05

Job Completion



W 06/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

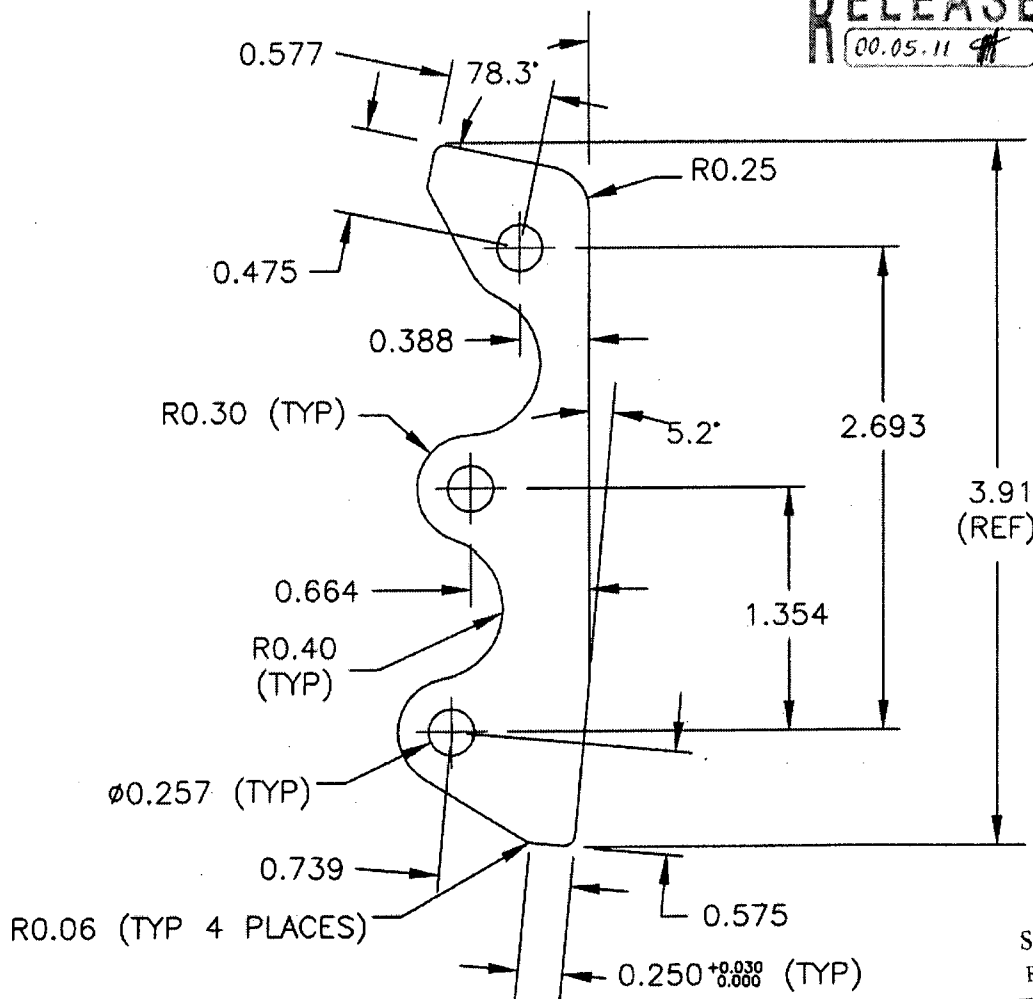
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2935	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	

RELEASED  
00.05.11 #



6061-T6

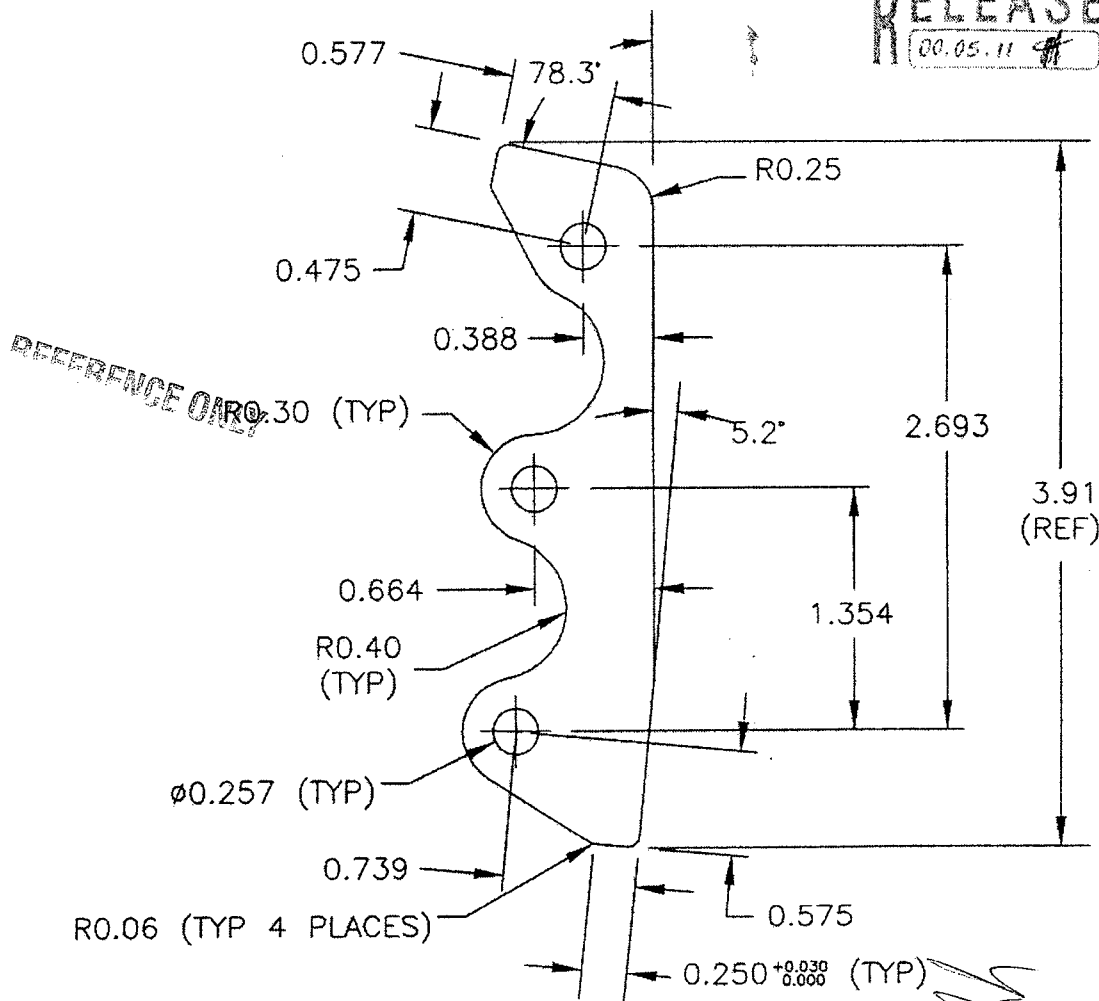
MATERIAL: ~~5052-H32/H34 (QQ-A-250/8)~~ 0.080 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27116



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2935	REV. A SHEET 1 OF 1
DATE 99.11.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	

RELEASED  
00.05.11 *[Signature]*



6061-T6 (AR-A-250/11) ———— — OR

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.080 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
BREAK ALL SHARP EDGES 0.010 TO 0.020

